

Date: Monday, 9/10/2007 1:27:47 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : 206 STEP END PLATE
Job Number : 34485	
Estimate Number : 11021	
P.O. Number : N/A	Part Number : D2734
This Issue : 9/10/2007 S.O. No. : N/A	Drawing Number : D2734 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : MACHINED PARTS	Drawing Revision : B
Previous Run : 33861	Material : N/A
	Due Date : 10/3/2007 Qty: 200 Um: Each
Written By : <u>[Signature]</u>	
Checked & Approved By : <u>[Signature]</u>	
Comment : Est:D 01.06.08 Removed Deburr EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M5052H32S063	5052-H32 .063 Sheet
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Comment: Qty.: 0.0656 sf(s)/Unit Total : 13.1250 sf(s)
 Material: 5052-H32 (QQ-A-250/8) 0.063" thick
 (M5052H32S.063) Batch: M103755

180 pieces

HB 07-09-12

M19296

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D2734

Dwg Rev: B 07-09-12

Prog Rev: B

DeDum →

204
 07/09/13 204

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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HB 07-09-12

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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QSP 015

counter

Comment: SECOND CHECK

En 07/09/13 204

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1
 Form per drawing D2734

8B 07/10/08 204

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/10/10
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: 206 STEP END PLATE

Job Number: 34485

Part Number: D2734

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



counts

Comment: INSPECT WORK TO CURRENT STEP

in 09/10/09 (x204)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: WA 3

09-10-12

(204)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



(204)

Comment: FINAL INSPECTION/W/O RELEASE

09/10/10

Job Completion



in 09/10/12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

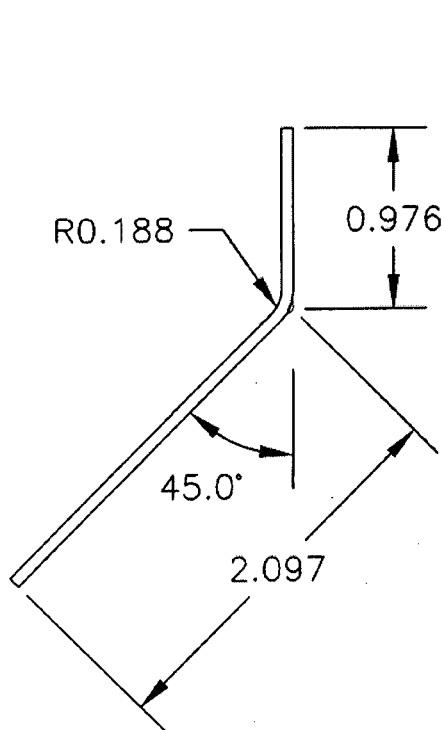
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

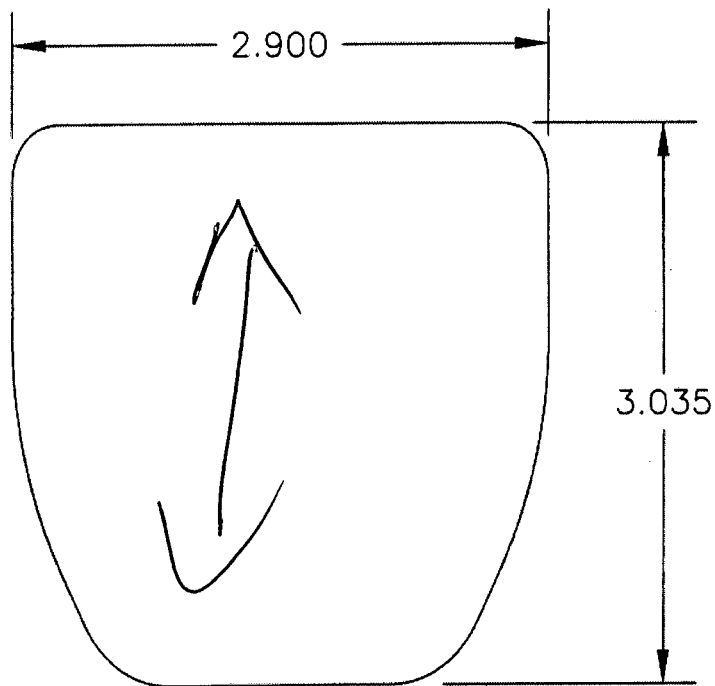


DESIGN KE	DRAWN BY KE	DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA	
CHECKED RH	APPROVED S	DRAWING NO. D2734	REV. B SHEET 1 OF 1
DATE 98.10.05	TITLE END PLATE		SCALE 1:1
A	97.12.10	NEW ISSUE	
B	98.10.05	0.976 WAS 1.016, 2.097 WAS 2.137	

RELEASED
98/10/05 KE



BEND DETAIL



FLAT PATTERN

MATERIAL: 5052-H32 (QQ-A-250/8) OR
6061-T6 (QQ-A-250/11) 0.063 THICK
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WCRK ORDER
NO. 34485